

Work Order ID 160930

Friday, May 05, 2017 10:34:42 AM

160930

Page 1

Item ID: PB67-43001-235

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Outer Tube

Start Date: 5/9/2017 Start Qty: 7.00

7

Cust Item ID:

Required Date: 5/12/2017 Req'd Qty: 7.00

7

Customer:

Reference: SCHEDULED/U

Approvals:

Process Plan:

DAS
21
9-89

Date: MAY 05 2017

Cooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

B67-43001

D

100

0.00

100

Bandsaw

BAND SAW

Jeaspa Bandsaw

Memo

0.78

1- cut to length as per dwg
2- deburr

7

MAY 23 2017

DAS
13
9-89

110

0.71

110

Mill Conv

CONVENTIONAL MILLING MACHINE

Conventional Milling Machine

Memo

3.55

1- drill holes and mill slot as per dwg PB67-43001 USE DT8792
2- deburr

120

0.00

120

QC

Memo

Quality Control

QC - Inspect part completeness to step on W/O

0.00

7

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9-89

JUN 07 2017

20- Punch
issee P/O. meter machine as per dwg.
P/O: 36405

10- need
need + inspect as per dwg attached c/c + o/w 7XSP176-7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER :							
Misidentified ☐	☐	Past Due								

Work Order ID 160930

Friday, May 05, 2017 10:34:42 AM

160930

Page 2

Item ID: PB67-43001-235 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Outer Tube
Start Date: 5/9/2017 Start Qty: 7.00 ***7*** Cust Item ID:
Required Date: 5/12/2017 Req'd Qty: 7.00 ***7*** Customer:
Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>W18003</u>	0.00							
130									
Packaging	Memo	0.00				7		JUN 14 2017 AS	
Packaging								6	
								1-89	
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

17/6/13

DAS
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9-89

JUN 12 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

Picklist Print

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Work Order ID: 160930

160930

Parent Item: PB67-43001-235

PR67-43001-235

Parent Item Name: Outer Tube

Start Date: 5/9/2017

Required Date: 5/12/2017

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP Rev:A 08-07-24 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.750W.065		Purchased	No			100	f	50.3690	5.3125	39.14474	✓		
M6061T6T1 750W 065									**				
6061T6 RDTUBE 1.750 X 0.65W											MAY 23 2017		
DAS 13 9-89													

Location

Loc Qty

Loc Code

MAT016

50.369

M133700

7.681

M136283

42.688

m137541

DQA: _____ Date: _____

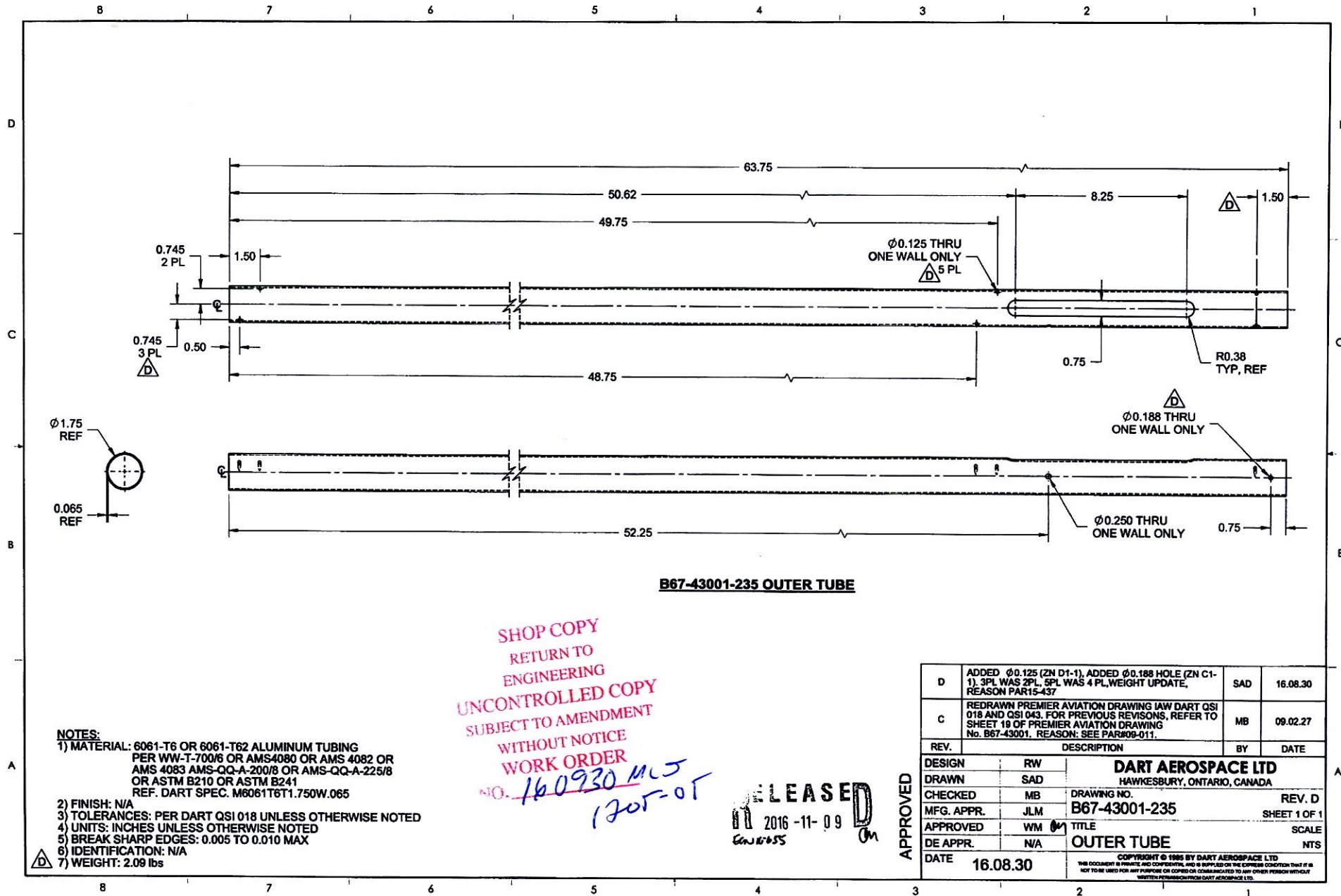


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36405**

Purchase Order Date 5/23/2017

PO Print Date 6/5/2017

Page Number 4 of 5

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613 678 3957

Ship To Contact

Ship To Phone

Ship Via:

Dart Truck

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 10

CAD

Destination-Collect

Line Total:

\$0.00

9 160949

PB67-43001-229 OUTER
TUBE

6/16/2017

7.00 ✓

\$0.00

\$0.00

Yes

6/16/2017

MACHINE AS PER DWG PB67-43001-229
MATERIAL 6061-T6 ROUND TUBING 1.750" X 0.065" WALL M137541

Line Total:

\$0.00

10 160930

PB67-43001-235 OUTER
TUBE

6/16/2017

7.00

\$0.00

\$0.00

Yes

6/16/2017

MACHINE AS PER DWG PB67-43001-235
MATERIAL 6061-T6 ROUND TUBING 1.750" X 0.065" WALL M137541

OAS
38
9-89

Line Total:

\$0.00

SP176-7

Note:

6/5/2017



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21723
Date: Jun 06, 2017
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 36405	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: Jun 06, 2017

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D5159-3 Seat Rib, as per drawing D5159-3 Rev. A	Each	6	6	
PB67-43001-127 Handle Arm, as per drawing PB67-43001-127	Each	5		
PB67-43001-257 Inner Tube, as per drawing PB67-43001-257	Each	7		
PB67-43001-247 Inner Tube, as per drawing PB67-43001-247	Each	6		
PB67-43001-255 Inner Tube, as per drawing PB67-43001-255	Each	7		
PB67-43001-259 Inner Tube, as per drawing PB67-43001-259	Each	7		
PB67-43001-285 Upper Tube, as per drawing PB67-43001-285 *** please note that 1 piece has an extra hole in wrong position (marked red) ***	Each	5	5	
PB67-43001-197 Outer Tube, as per drawing PB67-43001-197	Each	7	7	
PB67-43001-229 Outer Tube, as per drawing PB67-43001-229	Each	7	7	
PB67-43001-235 Outer Tube, as per drawing PB67-43001-235	Each	7	7	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				

DAS
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9-89

Received by

Sp H. 167

Thank you for your order!



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

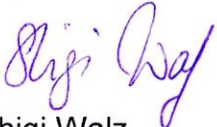
same

Quantity	Part Number	Part Name	Material & Batch #	P.O. Number
6	D5159-3	Seat Rib	SS304 square tubing 0.750" x .049" wall M137401	36405
5	PB67-43001-285	Upper Tube	6061-T6 round tubing 1.500" x .125" wall M133966, M135028	36405
7	PB67-43001-197	Outer Tube	6061-T6 round tubing 1.750" x 0.065" wall M137541	36405
7	PB67-43001-229	Outer Tube	6061-T6 round tubing 1.750" x 0.065" wall M137541	36405
7 ✓	PB67-43001-235 ✓	Outer Tube	6061-T6 round tubing 1.750" x 0.065" wall M137541	36405

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, June 6, 2017